Work Order ID 70127 Friday, May 27, 2011 10:56:58 AM					Page 1
	rt Qty: 6.00		Cust Item ID: Customer:	Setup Star	
Reference: Approvals: Process Plan: QC:		27 Tooling: SPC (Y/N):	Date:	Run Star — Stop	
	ration ription	Set Up/ Run Hours	Tool ID Tool # Pla Coo	1 ,	Reject Insp. Number Stamp
Draw Nbr Revision !	Nbr		,		
D3205 Rev A					
Bandsaw Jeaspa Bandsaw	D SAW Memo Cut blanks: 3.250" x 2.500" x 4.25	0.00 0.00 50" long Bar (+0.030/-0.000)	only oblog	6 18	·
HAAS I HAAS CNC vertical machine #1	S CNC VERTICAL MACHINING #1 Memo Machine D3205-1 as per Folio FA Deburr and Tumble	0.00	Thouso		
120 QC2-	Inspect parts off machine FAI/FAIB Memo	0.00	m/u/o6/10	le p	

Quality Control

W/O:			V	ORK ORDER CHANGE	S	········		
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Cat	tegory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	_ Disposit	ion:	QA: N/C Clo	sed:	Date: _	*
NCR:	ICR:			DER NON-CONFORMA	NCE (NCR))		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date			
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• • •			MATON MAIN MINER TO VAN	1 1961 (1961 1961	188 188 188 188 1					
Work Ord Friday, May 27										
Item ID: Revision ID:	D3205-1			Accept					Setup	Start
Item Name:	Pedal Bracket									Stop
Start Date: Required Date Reference:	6/2/2011 e: 6/6/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item I Customer:	D:				
Approvals:	Process Pla	in:	Date:	Tooling:	Da	 nte:]	Run	Start
	QC:		Date:	_ SPC (Y/N):	Da	ıte:				Stop
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty	
QC Quality Control	s.	QC8- Inspect parts - sec	ond check	0.00 B.	4 11/06/14			6	9	<i>f</i>
140		Chemical Conversion Co	oat per QSI005 4.1	0.00				f		<i>(</i>
HandFinish Hand Finishing		Memo		0.00				_ 6	. !	φ

150

Powdercoat

Powder Coating

MM6

A

B

B

Coating

Grey Sandtex(Ref:4,3,5.6) per QSI005 4.3

0.00

Memo

Note: Cover the thread hole for D3205-1 before powder coat.

TIME:

OVEN TEMPERATURE:

30

0.00

Note: Cover the thread hole for D3205-1 before powder coat.

START

TIME:

TOWN TEMPERATURE:

30

0.00



Page 2



eject Insp. umber Stamp

6x 6 m-f 17/06/14

Dail Ac	ospace	LU									· +
W/O:			V	ORK OR	DER CHA	ANGES	S				
DATE	STEP	PROC	EDURE CH	ANGE		-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	_ Fault Ca	tegory:			NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition:				QA: N/C C	losed:		Date: _	
NCR:		W	ORK OR	DER NON	I-CONFO	RMAN	CE (NC	R)	-		
DATE	STEP	Description of NC		Correctiv		Section		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Acti	ion Descrip Chief Eng	tion ———	Sign Date		ion C	Chief Eng	QC Inspector
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Work Order ID 70127

Friday, May 27, 2011 10:56:58 AM



Page 3

Item ID:

D3205-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Pedal Bracket

Start Date:

6/2/2011

Start Qty: 6.00

Required Date: 6/6/2011

Req'd Qty: 6.00



Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

QC:

Date: Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Bf 11-6-14.

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Duit Au	- Copuso								1
W/O:			WO	RK ORDER CHANGE	S			•,	
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQ	A:	Date:	-
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NCR:			VORK ORDE	R NON-CONFORMAL	NCE (NCR	1)		*	
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Picklist Print

Friday, May 27, 2011 10:57:05 AM

Work Order ID: 70127

Parent Item: D3205-1

Parent Item Name: Pedal Bracket



Start Date: 6/2/2011

Required Date: 6/6/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A□04.06.09□New issue□KJ/RF□

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2		Purchased	No			100	f	10.5000	0.3646	2.302737	,		

7075-T73 Bar 2.50 x 3.25

Location Loc Qty Loc Code MAT008 10.5 10.5 116680

2.31 on Luloudas

W/O:								
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Cat	tegory:	_ NCR: Yes !	No DQA:	Date: _	·
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NCR:	-	W	ORK ORI	DER NON-CONFORMA	ANCE (NCR)	, ,		
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	70127
Description: Pedal Bracket	Part Number:	D3205-1
Inspection Dwg: D3205 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.103	_		Vern ML.	>
0.250	+/-0.010	.250			, (
R0.37	+/-0.030	R. 375			R-6	
0.125	+/-0.010	.13/			VernHl-	>
0.250	+/-0.010	. 257			1 +	
2.380	+/-0.010	2.378			11	
1.380	+/-0.005	1.379			11	
0.500	+/-0.005	.499			11	
0.880	+/-0.010	-88/	_		į (
Ø0.470 x 100°	+0.005/-0.000	Ø.475 X100°			,1	
0.440	+/-0.005	440	_		, (
0.600	+/-0.005	. 598			1-	
1/4-28UNF-313	N/A	14-28 UNF-313			• (
0.250	+/-0.010	, 251			٤ (
Ø0.257	+0.005/-0.000	B.259			" (
1.750	+/-0.010	1.752			, 1	
0.870	+/-0.005	. 870			11	
0.440	+/-0.005	.440			.,	
R0.25	+/-0.030	R.250			R-6-	
		,				

Measured by:	ml	Audited by:	B A	Prototype Approval:	N/A
Date:	1/06/18	Date:	11/06/14	Date:	N/A
Rev Date	Change			Pavised by	Annroyad

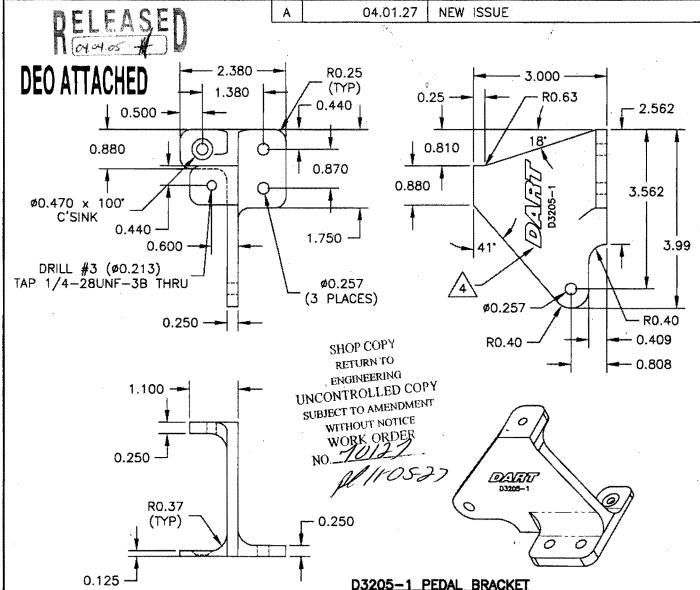
A 05.02.17 New Issue

W/O:			w	ORK ORDER CHA	NGES					
DATE	STEP	PROCI	EDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	egory:	NC	R: Yes N	lo DQA		Date:	
	R	esolution:	Disposition	on:	QA	: N/C Clo	sed:		Date: _	
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DATE	STEP	Description of NC			Section B	O ** • •	Verifica	ation	Approval	Approval
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DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
4	N	D3205	SHEET 1 OF 2
DATE		TITLE	SCALE
04.01.27		BRACKET	1:2



- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12) OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- ENGRAVE DART P/N & LOGO AS SHOWN
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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Dart Aerospace L	_td
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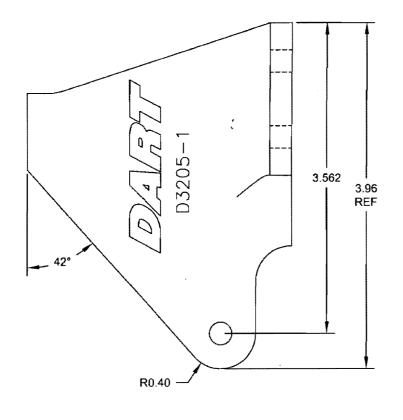
W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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NCR:		1	WORK ORDER NON-CONFORMANCE (NCR)											
DATE	CTED	Description of NC	Corrective Action Section B			Verifica		ation	tion Approval	Approval				
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No	DQA: _	e:			
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DATE	STEP	Description of NC	Corrective Action Section B			Verification				Approval	
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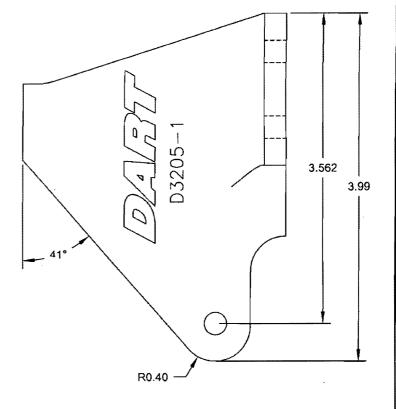
DRAWING	NQ.	TITLE			REV. A	DART AER	OSPACE LTD	D.E.O. NO.		SHEET N	Ю.	SCALE
D3205		BRACKET		ı		ENGINEE	RING ORDER	D3205-A-1	_	SHEET 1 C)F 1	NTS
DRAWN	AJS		CHECKED	1	5	MFG. APPR		APPROVED	W	DE APPR.	<u> </u>	
DATE	08.12.	01	DATE	08.12	2.01		-77	DATE 4	08/12/01	DATE 08.1	2.0	

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS: W/0 70127



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W/O:			V	ORK ORDER CHANG	ES				*	ļ	
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Ca	tegory:	_ NCF	R: Yes	No DQ	A:	Date:		
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DATE	0:550	Description of NC	Description of NC Corrective Action Section B					ation	Approval	Approval	
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NOTE: Date & initial all entries